

Work Order ID 78941***78941***

Page 1

January-17-12 1:29:40 PM

Item ID: D3140-06

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.J.Date: 12/01/17

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

1 12/09/21/15

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

① 12-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78941

78941

Page 2

January-17-12 1:29:40 PM

Item ID: D3140-06 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door
 Start Date: 17/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>16439</u>								
	Purchase Part Number: D3140-06								
	Supplier: Delastek								
	Ship kit and make as per dwg								
	Conformity Certificate and Process sheet required								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

CL 12/02/17 ①

1/23/18 ①

① 13.12.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78941

78941

Page 3

January-17-12 1:29:40 PM

Item ID: D3140-06 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door
 Start Date: 17/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

① 13.12.16

13/12/18

13-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-17-12 1:29:44 PM

Page 1

Work Order ID: 78941

78941

Parent Item: D3140-06

D3140-06

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-87 *D3140-87* Doubler		Manufactured	No			100	Each	0.0000	1	1			
									**	B90778		12/09/21	
D3140-95 *D3140-95* Doubler		Manufactured	No			100	Each	7.0000	3	3	✓		
									**			JB	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST028			7					52265	
				52265			7						
D3140-98 *D3140-98* Doubler		Manufactured	No			100	Each	4.0000	1	1			
									**			JB	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				CA			4					34376	
				34376			4						
D3140-241 *D3140-241* Doubler		Manufactured	No			100	Each	0.0000	1	1	✓		
									**	78723		JB	
D3140-303 *D3140-303* Doubler		Manufactured	No			100	Each	0.0000	1	1	✓		
									**	84215		JB	12/09/21

D3140-06P

12/3/8/8 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHOWN COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78941 M.L.S.
12/01/17

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY E.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

F

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117887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

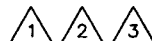
[illegible]

RELEASED

06.11.13

SECTION B-B

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN

CHECKB

DATE	
------	--

06.10.06

DRAWN BY

APPROVED

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO.

D3140

[illegible]

DOOR

REV. F

SHEET 3 OF 7

SCALE

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

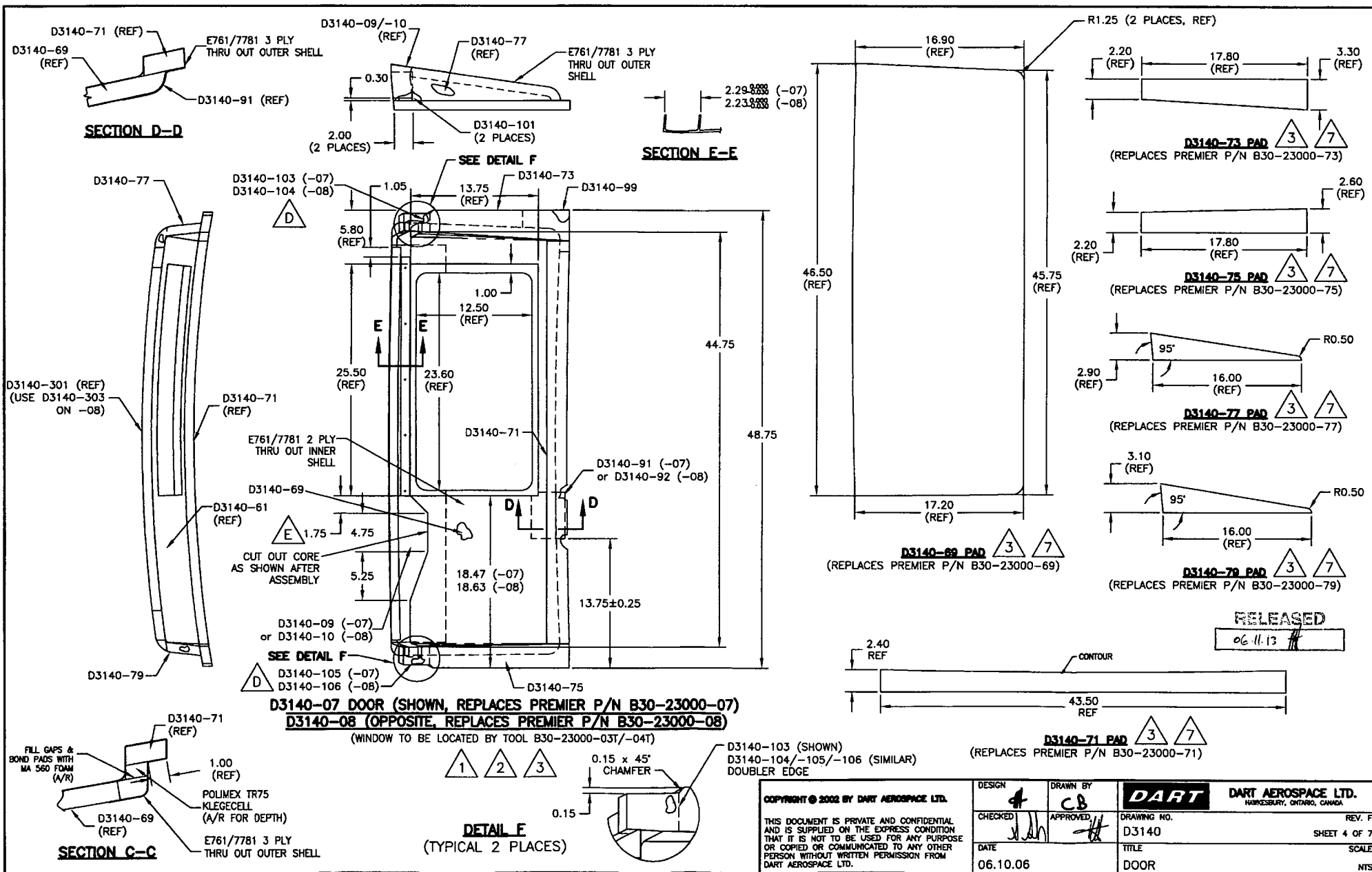
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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78941



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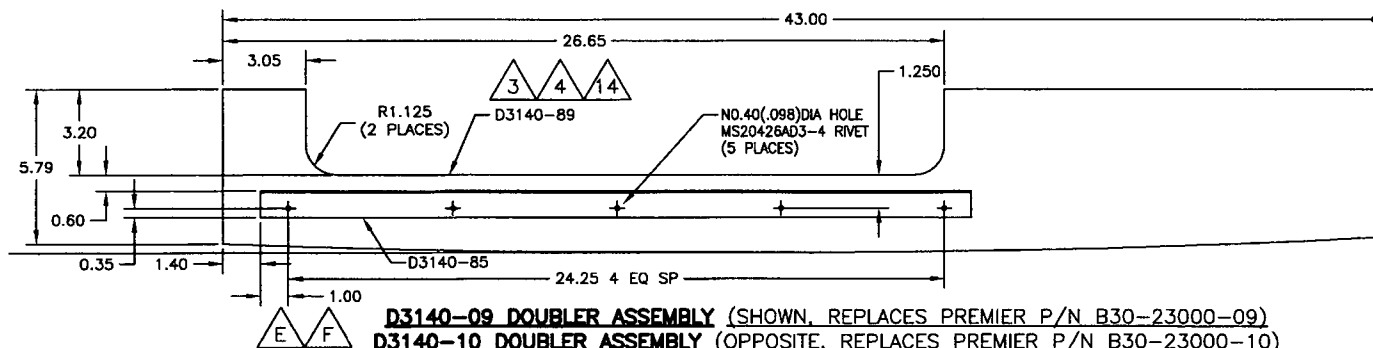
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

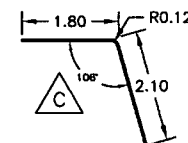
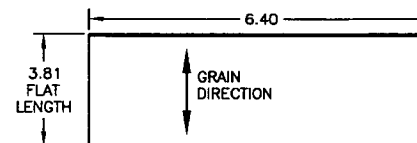
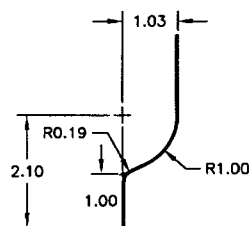
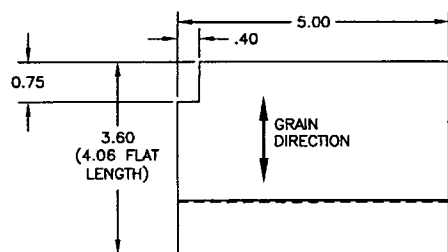
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78941

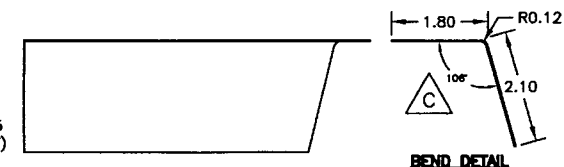
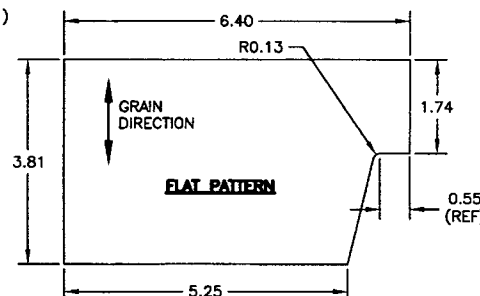
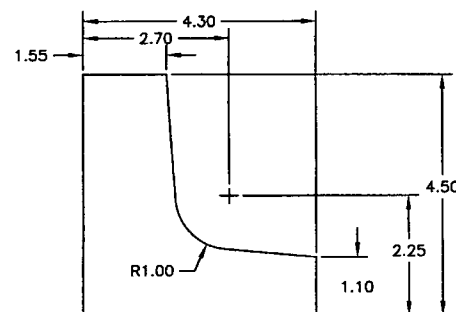


D3140-101 DOUBLER (REPLACES PREMIER P/N B30-23000-101)



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BEND DETAIL

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DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

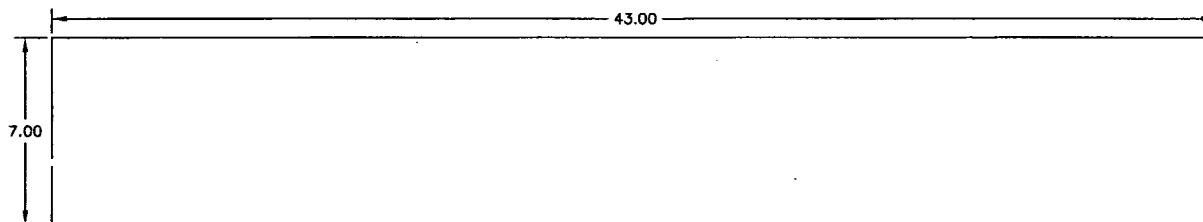
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

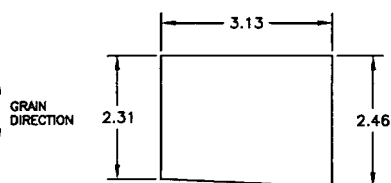
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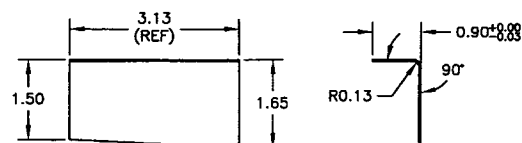
78941



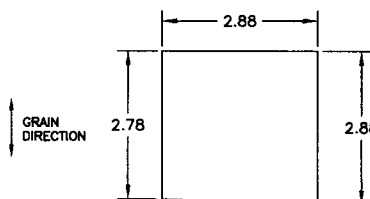
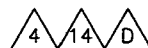
D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



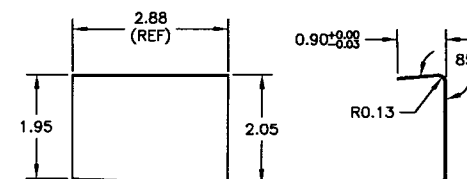
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



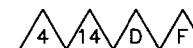
D3140-105 DOUBLER
D3140-106 OPPOSITE



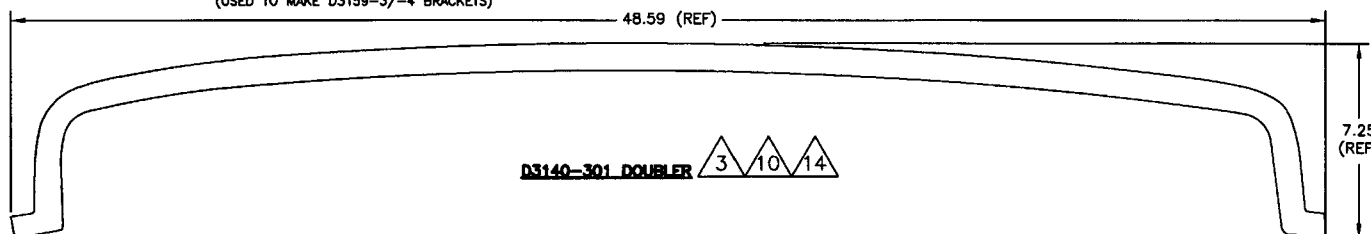
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



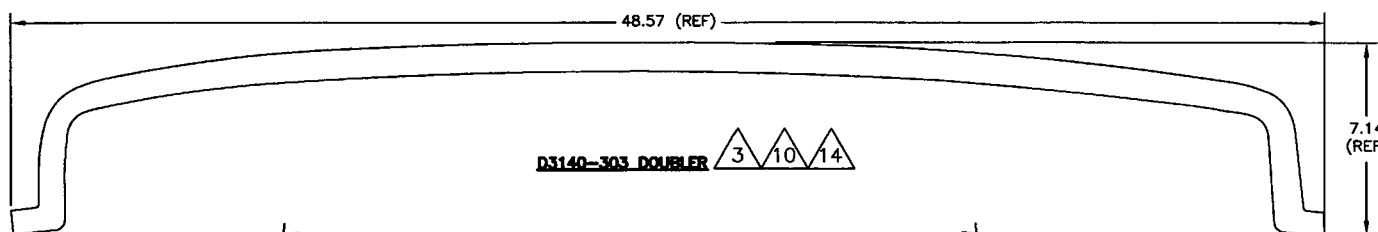
D3140-104 DOUBLER
D3140-103 OPPOSITE



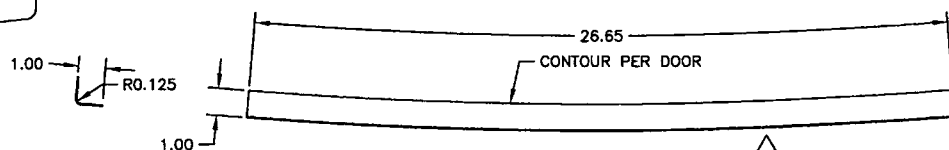
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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DESIGN 4	DRAWN BY CB	DART DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 6 OF 7 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

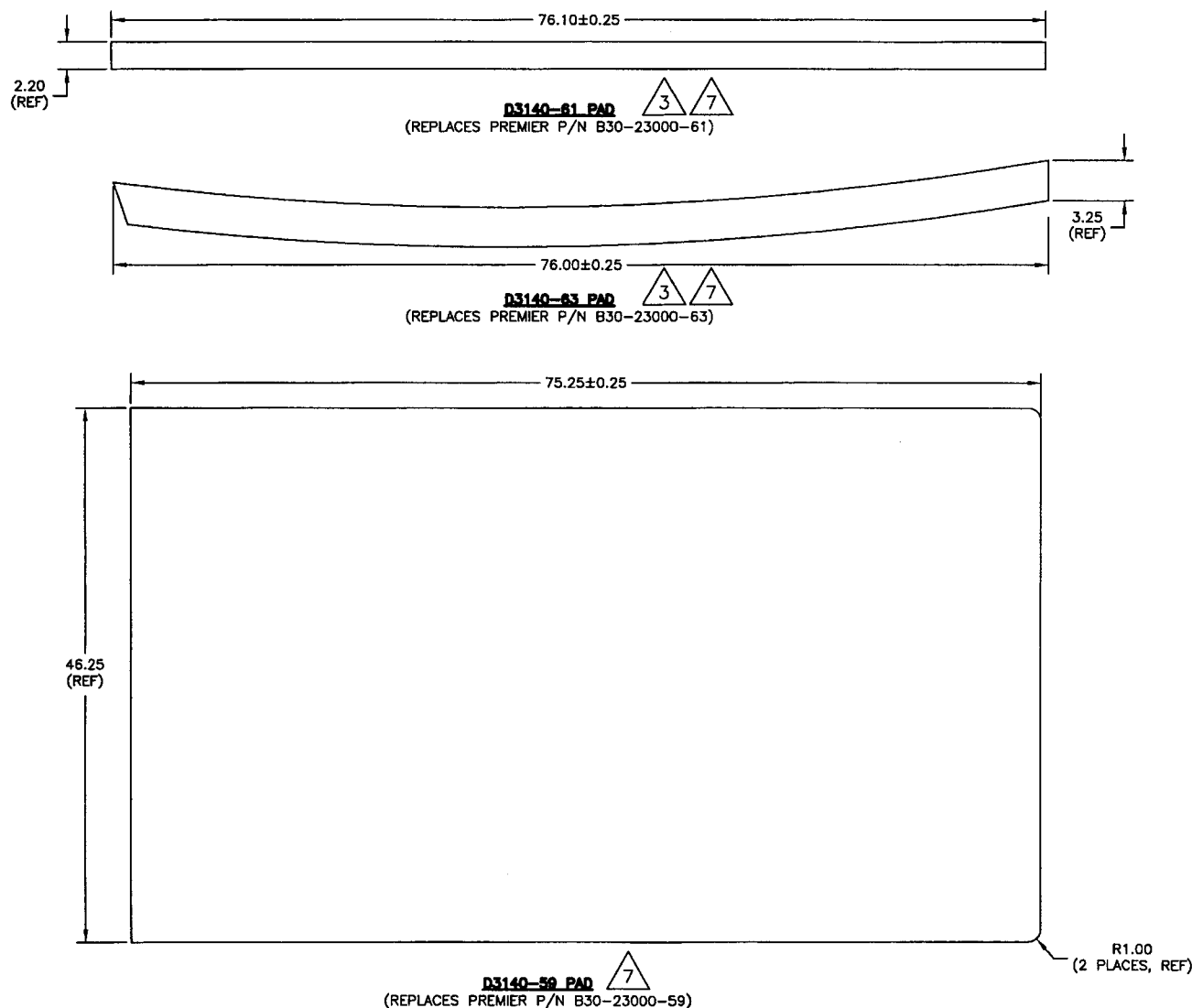
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78941



RELEASED

06.11.13

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DART AEROSPACE LTD.

DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED JAH	APPROVED	DRAWING NO. D3140	REV. F SHEET 7 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Mastering, Inc. 05/04/04

DELASTEK

DELASTEK Inc.
2699, 5e Avenue
Local 14, C.P.-10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	47937
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada



Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-05-2013	16-03-2012	20221	Chantal Lavoie	PO16439	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Day & Ross Collect	Point de départ	Mathieu Doucet, ext.690			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC135-0019	Line #2 D3140-06 Door Right Non Assy (Grosse) U of M: Chaque B78941 DWG D3140 REV. F Serial # Lot # 40734. 40734	
1	0	1	DKC135-0020	Line #4 D3140-08 Door Right Non Assy (Petite) U of M: Chaque B78943 DWG D3140 REV. F Serial # Lot # 40734. 40734	

43/017

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 40734
Numéro Soumission : 3407
Numéro B.A. :
Cette fois : 2012-04-26 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 40172

Nom Dessin : DOOR KIT
Numéro Article : DKC135-0019/-0020
Numéro Dessin : D3140
Projet Numéro : DK-359
Révision dessin : F
Matériel : Fibercote E-761
Date Dûe : 2012-07-02

Qté: 1 Udm: UNITE

Écrit par

Vérifié & Approuvé par

Commentaires

N° de pièce Client: D3140-06/-08

Process Sheet Rév.: 05 remplacer AAC0559 et AAC0563 par
AAC2032 et AAC1361 respectivement, changé AC0883 et AC0884
par AAC1885 et AAC1887 respectivement à 2 endroits qui avait
étés oubliés

RNC7271

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0 AAC0854

Frekote #700-NC

Commentair Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)
Frekote #700-NC N° de Lot 1-33991-1

2.0 PRÉPARATION

Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs



Faire la préparation du moule selon IF135-0002 et 135-0009

Date: 18-09-12 Sceau:



3.0 AMB0211

Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)
Epoxy prepreg E-761 style 7781 N° de Lot 1-35874-1

4.0 DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs



Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi. (7 Paquet = 24.5 verges)

Quantité: 1 Date: 18-09-12 Sceau:



Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

5.0

DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002

Quantité: 1

Date: 19-09-12 Sceau:



6.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

Tissu à délaminer Release ply B

de Lot: 2-32882-1

7.0

AAC1887

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

Wrighton 5200 Bleu P3

de Lot: 1-33715-2

8.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

9.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total: 7.770 VERGE(s)

10.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total: 2.0000 ROULEAU(s)

11.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le bagging sur la pièce selon IF135-0002 et IG 0012.

Quantité: 1

Date: 20-09-12 Sceau:



12.0

CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N° Cuisson: 70

Quantité: 1

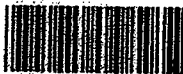
Date: 20/09/12 Sceau:



13.0

DÉMOULAGE

Démoulage de la pièce



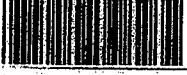


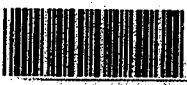







Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: DOOR KIT	
Numéro Job: 40734		Numéro Article: DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Quantité: 1	Date: 24-09-12	Sceau: 
14.0	INSPECTION	Inspection générale	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.			
	Quantité: 1	Date: 21-12-12	Sceau: 
15.0	AAC1618	Rohacell 71S 1"thick 49.2" x 98.4" plain	
Commentaire Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s)			
Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: 1-37708-2			
16.0	DECOUPE	Découpe manuelle des pièces	
			
Commentaire Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs			
Faire la découpe des pièces de mousses structurales (Rohacell) sur la scie à ruban selon IF135-0002.			
	Quantité: 1	Date: 04/12/12	Sceau: 
17.0	SÉCHAGE/ ANEAL	Séchage /Anéaling	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le séchage du Rohacell selon IF135-0002 et les informations du manufacturier. N°			
Cuisson: 72.8			
	Quantité: 1	Date: 29/11/12	Sceau: 
18.0	AMB0442	Film adhésif de EA9696 36" large x 0.06 (psf)	
Commentaire Qty.: 6.12 VERGE CAR(s)/Unit Total : 6.12 VERGE CAR(s)			
Film adhésif de EA9696 36" large x 0.06 (psf) N° de Lot: 2-35855-2			
19.0	AAC2032	Core splice adhesive NB-51/301	
Commentaire Qty.: 5.0 PIED CARRE(s)/Unit Total : 5.0 PIED CARRE(s)			
Core splice adhesive NB-51/301 # de Lot: 1-36395-1			
20.0	AAC1361	Putty AD Tech P-17	
Commentaire Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)			
Putty AD Tech P-17 # de Lot: 1-38354-2			

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description:

21.0 AAC1646 N° D3140-10, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-10, Doubler

N° de Lot:

1-37826-1

22.0 AAC1631 N° D3140-87, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-87, Doubler

N° de Lot:

1-37871-1

23.0 AAC1633 N° D3140-92, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-92, Doubler

N° de Lot:

1-37826-2

24.0 AAC1634 N° D3140-95, Doubler

Commentair Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)

N° D3140-95, Doubler

N° de Lot:

1-37826-19

25.0 AAC1636 N° D3140-98, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-98, Doubler

N° de Lot:

1-37826-20

26.0 AAC1637 N° D3140-99, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-99, Doubler

N° de Lot:

1-37826-3

27.0 AAC1638 N° D3140-101, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

N° D3140-101, Doubler

N° de Lot:

1-37826-4

28.0 AAC1640 N° D3140-104, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-104, Doubler

N° de Lot:

1-37826-5

29.0 AAC1642 N° D3140-106, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-106, Doubler

N° de Lot:

1-37826-6

30.0 AAC1643 N° D3140-241, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-241, Doubler

N° de Lot:

1-37826-10

31.0 AAC1645 N° D3140-303, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

N° D3140-303, Doubler

N° de Lot:

1-37826-7 et 1-37826-22

32.0 NETTOYAGE Nettoyage des pièces



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doublers selon IG 0063.

















Quantité: 1

Date: 23-1-2013

Sceau:

-Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: DOOR KIT	
Numéro Job: 40734		Numéro Article: DKC135-0019/0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentaire Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Mise en place des doublers et des pièces de la mousse structurale selon IF135-0002.			
Quantité: 1 Date: 24-1-2013 Sceau:   			
34.0	AAC1885	Tissu à délaminer Release ply B	
Commentaire Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)			
35.0	AAC1887	Wrighton 5200 Bleu P3	
Commentaire Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)			
36.0	AC0885	Feutre de drainage N° Airweave N 10	
Commentaire Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)			
37.0	AC0882	Sac à vide N° Stretchlon 700	
Commentaire Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)			
38.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Commentaire Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)			
39.0	BAGGING	Faire le bagging sur la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le montage cuisson selon IF135-0002 et IG 0012.			
Quantité: 1 Date: 29-01-2013 Sceau:   			
40.0	CUISSON	Cuisson de pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #21. N° Cuisson: 7036			
Quantité: 1 Date: 29-01-13 Sceau: 4254 m L			
41.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Retirer le montage cuisson de sur la pièce et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium. Garder seulement la barre qui sépare les deux pièces.			
Quantité: 1 Date: 28/01/13 Sceau: 			

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

42.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousses structurales selon IF135-0002 et installer les doublers

Quantité: 1

Date: 7/02/13

Sceau:



43.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Quantité: 1

Date: 7/02/13

Sceau:



44.0

AMB0211

Epoxy prepeg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)
Epoxy prepeg E-761 style 7781 N° de Lot: 1-36396-1

45.0

DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Drapage de la coquille intérieure selon IF135-0002

Quantité: 1

Date: 22-02-13

Sceau:



46.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

47.0

AAC1887

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

48.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

49.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

50.0

AC0886

Ruban à gommer jaune #: TIAT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

51.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité: 1

Date: 22-02-13

Sceau:



52.0

CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N° Cuisson: 7412

Quantité: 1

Date: 22/02/12

Sceau:

254

53.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.

Retirer la pièce du moule.

Quantité: 1

Date: 27-2-2013

Sceau:



54.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnelle".

Quantité:

Date:

Sceau:

Non fait par QA



16 avri/2013 IV

55.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003.

Quantité: 1

Date: 27-2-2013

Sceau:



12-04-2013 JLT
H435

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40734

Numéro Article: DKC135-0019-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

56.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit

Total : 0.5000 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-36433-1

2 partie

Lot: 1-37302-1

57.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit

Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-38821-1

2 partie

Lot: 1-38821-1

58.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

première partie 01-03-13

Faire l'application du primer selon IG 0008.

Quantité: 1

Date: 16-04-13 Sceau: 43790N° fiche Mélange: N/A

59.0

SABLAGE

Sablage



Commentair Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003.

Quantité: 1

Date: 05/03/13 Sceau: 57

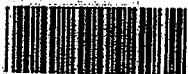


18/04/13 4433MM

60.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

première partie 05-03-13

Faire l'application du primer selon IG 0008.

2 partie

Quantité: 1

Date: 18-04-13 Sceau: 57



N° fiche Mélange: N/A

61.0

IDENTIFICATION

Identification des pièces



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanismes de porte selon IG 0055.

N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08

N° de Job (sur les 2 pièces): 40734

Date de fabrication (sur les 2 pièces): 06/03/2013 19/04/2013

Sceau d'inspection.

Quantité: 1

Date: 06/03/2013 Sceau: 57

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40734

Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

62.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1 kit

Date: 23 avr. 13

Sceau:



63.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057.

Quantité: 1 kit

Date: 3/5/13

Sceau:



IDENTIFICATION DE LA PIÈCE

Fournisseur	Client	Numéro dessin	Rév.	Numéro de Pièces	
Delastek Aéronautique	Dart Aerospace Ltd.	D3140-06/08	F	DK	DK-359- - -
No. de commande	Nom du produit	No Travail	No Série	Article	Article
N/A	DOOR KIT	40734	N/A	Client	D3140-0019/002
Garantie (Oui/Non)	NON			Quantité	1

DESCRIPTION DE LA NON-CONFORMITÉ

Cause	Mauvaise adhérence	Responsabilité	Composite
Situation requise		Situation actuelle	
Aucune bulles entre les tissus		Suite à l'inspection de tap test, il y a des bulles d'air qui ont été emprisonnées entre les tissus.	

Impact réel et potentiel	(Oui/Non)	Coût associé	
Effets sur produits en inventaire	NON	N/A	N/A
Effets sur produits en cours	NON		
Effets sur produits livrés	NON		
Autres effets réels ou potentiel	NON		

DISPOSITION DU PRODUIT NON-CONFORME

Accepté tel quel	Retouche	Dérivation	X	Réparation	Rebut	Autres
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DÉTAIL SUR LA DISPOSITION

Percez un trou de 1/8" aux endroits en fautes.				
DISPOSITION	COMPLÉTÉ PAR	DATE	TEMPS	TAUX

No Travail de réparation :

N/A

Conformité après correction

OUI ☐

NON ☒

Disposition finale:

N/A

ACTION PREVENTIVE/CORRECTIVE REQUISE

NON ☒

OUI ☐

Numéro : N/A

COMPLÉTÉ PAR LE SERVICE APRÈS-VENTE (SIREQUIS)

BON LIVRAISON	N/A	B/VAM	N/A
No. RMA	N/A	RNC Client	N/A
DATE RECEPTION	N/A	WATBILT	N/A
DATE EXPEDITION	N/A	CERTIFICAT	N/A

COÛT DE LA NON-CONFORMITÉ

ADMINISTRATION	35.00 \$
MATÉRIEL PREMIÈRE	- \$
EXPERTISE	- \$
MAIN D'ŒUVRE	- \$
TRANSPORT	- \$
AUTRE	- \$
TOTAL	35.00 \$

Devise

☐ USD

☒ CAD

AUTHENTIFICATION

COMPLÉTÉ PAR Isabelle Veillette

INSPECTÉ PAR Isabelle Veillette

APPROUVÉ PAR _____

DATE 2013-02-28 SCEAU _____

DATE 2013-02-28 SCEAU _____

DATE _____ SCEAU _____